Date: Monday, 3/26/2007 12:50:06 PM
User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 31479
Estimate Number : 12806
P.O. Number : N/A
This Issue : 3/26/2007 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : SMALL /MED FAB
Previous Run : N/A
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07-03.26 ec

Drawing Name : BRACKET
Part Number : D35702
Drawing Number : D3570 UNDER REVIEW
Project Number : N/A
Drawing Revision : U/R
Material : N/A
Due Date : 4/2/2007 **Qty:** 2 **Um:** Each

Additional Product -

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet

Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.1491 sf(s)
6061-T6 .125 Sheet
Batch: M103156
M 07 03 27
Grain must be Along 4.63"*******
(2)

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3570
Dwg Rev: U/R
Prog Rev: U/R M 07 03 27
(2)
2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

M 07 03 27 (2)
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK 07 03.27 (2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Form as per Dwg D3570 N/A

Form: rprocess

Date: Monday, 3/26/2007 12:50:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BRACKET

Job Number: 31479 **Part Number:** D35702

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	
8.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
10.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock Location:_____	
11.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	

ENGINEERING APPROVAL

07.03.27 07.03.27

N/A

FOR ENGINEERING USE ONLY

FOR ENGINEERING USE ONLY

03.07.27

07/03/29

Job Completion

07.03.29

6.1 Drill Holes IAW Dwg. D3570 and TrIM

0703 29

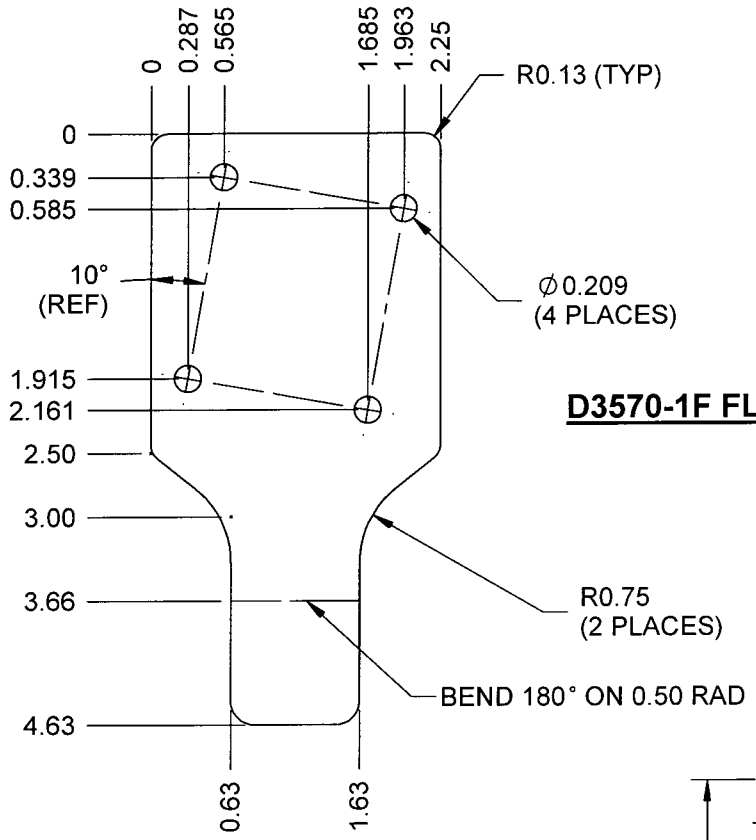
Form: rprocess

PRELIMINARY ISSUE

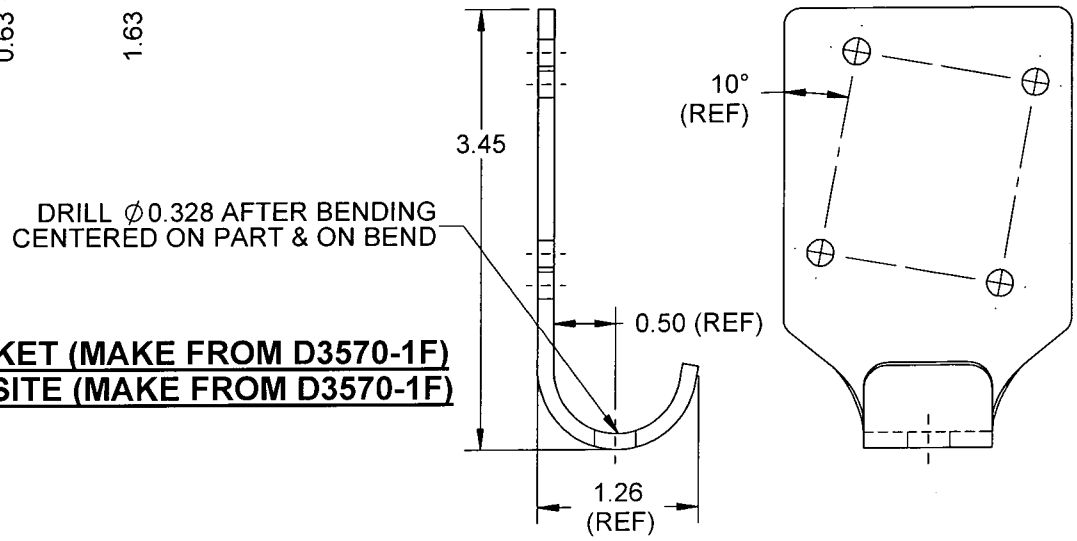
UNDER REVIEW
07.03.21 LE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
LE	LE		
CHECKED	APPROVED	DRAWING NO. D3570	REV. A SHEET 1 OF 1
DATE 07.02.07		TITLE BRACKET	SCALE 2:3

REV	DATE	DESCRIPTION
A	07.02.07	NEW ISSUE



D3570-1F FLAT PATTERN



D3570-1 BRACKET (MAKE FROM D3570-1F)
D3570-2 OPPOSITE (MAKE FROM D3570-1F)

NOTES:
1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027
(REF DART SPEC M6061T6S.125)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

DART AEROSPACE LTD	Work Order:	31479
Description: Bracket	Part Number:	D3570-2
Inspection Dwg: D3570 Rev: U/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☑ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	2.25	+/- 0.030	2.253	✓		Vern	
B	4.63	+/- 0.030	4.63	✓		Vern	
C	R0.13	+/- 0.030	R0.13	✓		Radius Gauge	
D	2.250	+/- 0.030	2.50	✓		Vern	
E	3.00	+/- 0.030	3.00	✓		Vern	
F	0.63	+/- 0.030	0.610	✓		Hight Gauge	
G	1.63	+/- 0.030	1.60	✓		Hight Gauge	
H							
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by:	MM	Audited by:	[illegible]	Prototype Approval:	[illegible]
Date:	07 03 27	Date:	07.03.27	Date:	07.03.27

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

VERIFIED TRUE COPY OF ORIGINAL DOCUMENTS

AMARI METALS B.V.

149387

ALCOA

Alcoa Europe

Flat Rolled Products
Alcoa Trasformazioni srl
Stabilimento di Fusina
Via dell'Elettronica 31
30030 Malcontenta
Loc. Fusina (Venezia)
Italia
Tel: 39 041 2917111
Fax: 39 041 2917170

INSPECTION CERTIFICATE

EN 10204 3.1

Ordernumber Alcoa 600198001
Date 24/03/2006

Shipment doc.rif. 003820

AMARI METALS BV
P.O. BOX 1274
3430 BG NIEUWEGEIN NL
NETHERLANDS

Vs.ordine nr.	Your alloy	Your temper	Quantity
055779DRB23800	6061	T6	13283 Libbre

Global specification

ALU SHEET 6061 T6 B209/AMS QQA
Dimensions T*W*L 0,1250 x 48,00 x 96,00 Pollici

Remarks

THE PRODUCT MEETS ALL REQUIREMENTS OF:
AMS 4027 AMS QQ-A-250/11 ASTM B209
THE PRODUCT MEETS ALL REQUIREMENTS OF:
AMS 4027 AMS QQ-A-250/11 ASTM B209

Chemical composition 6061

Cast nr		%Si	%Fe	%Cu	%Mn	%Mg	%Cr	%Ni	%Zn	%Ti	Altro %ognuno	Altro Totale
86018C5	TNT3A	0,74	0,44	0,24	0,070	1,06	0,13	0,0044	0,017	0,015		
Limit	Min.	0,40		0,15		0,80	0,040					
	Max.	0,80	0,70	0,40	0,15	1,20	0,35		0,25	0,15	0,050	0,15

Mechanical properties

Coil nr:	Pallet	Rm KSI	Rp0.2 KSI	A50 %
TNT3A		48	41	16
TNT3A		47	41	14
	0531817			
	0531818			
	0531819			
	0531820			
	Min.	42	35	10
	Max.			

Approved by
R. Signori Test.Lab.Supervisor

We hereby certify, that the material described above has been tested and complies with the terms of the comfirmation of order.